

Work Order ID 151706

Friday, October 07, 2016 2:33:17 PM

151706

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Item ID: D3512-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Spacer
Start Date: 10/4/2016 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 10/7/2016 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: VS [Signature] Date: 10/10/16 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3512	D								
100		0.00							PR 10/10/17
100	FLOW WATER JET								
Waterjet	Memo	0.04							
FLOW CNC Waterjet	1-Cut as per Dwg D3512 Dwg Rev: <u>D</u> Prog Rev: <u>P</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.01							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.02							
Quality Control									

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	Form as per dwg NC BRAKE Memo	0.06 0.02			DAS 30 9-89	⑥			OCT 27 2016
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.02				6			DAS 38 9-89 OCT 27 2016
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo LOCATION: WA001	0.00 0.01				6			DAS 6 9-89 OCT 31 2016

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Required Date: 10/7/2016 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.10							
Quality Control									

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Handwritten signature and date: 10/6-10/31

Picklist Print

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Parent Item: D3512-3

D3512-3

Parent Item Name: Spacer

Start Date: 10/4/2016

Required Date: 10/7/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 13.07.19 NEW ISSUE DD VERF:JLM IPP
REV:B 13.12.11 ECN13-619/ REV.D DWG DD VERF:JLM

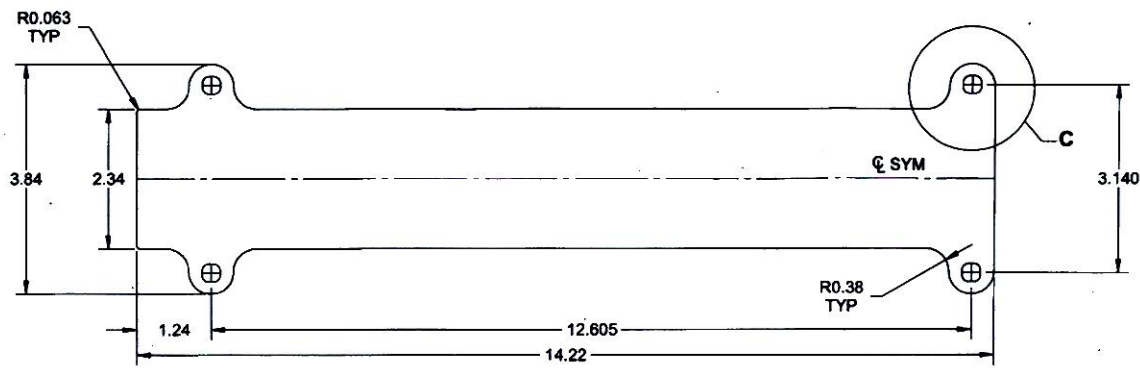
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased		No		100	sf	171.6240	0.0943	0.595579			

M304S18GA

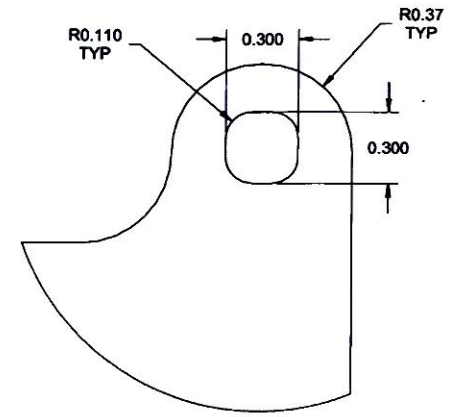
304/316 .050 Sheet

PR 10/10/17

Location	Loc Qty	Loc Code
MAT020	65.9	
M133328	55.224	
M133587	0.7	
M134824	20.7	
M134982	20.2	
M135779	65.9	<i>0.6</i>
MAT20	8.9	
M134580	8.9	



D3512-1F



DETAIL C
SCALE 2X

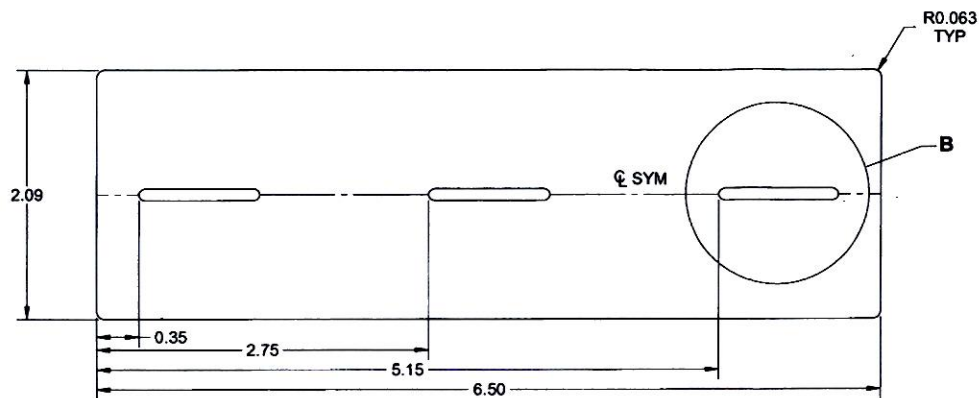
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 151706

vic
1.2
16/10/11

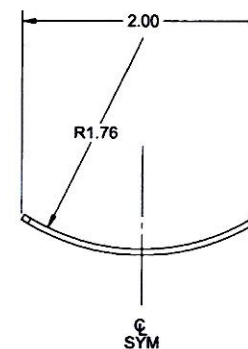
RELEASED
2013-12-10
WP

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 18 GAUGE 0.063 THICK (REF DART SPEC. MS304S16GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.63 lbs

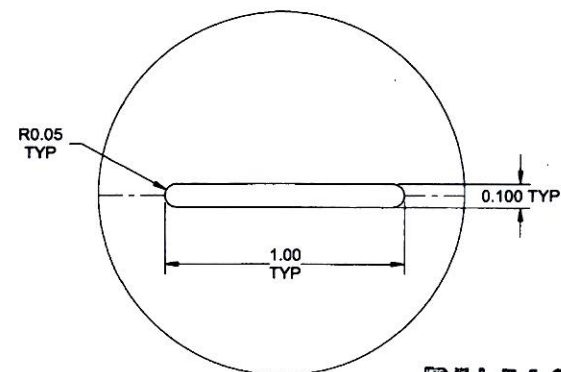
DESIGN	DW	DART AEROSPACE LTD	
DRAWN	DW	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>MD</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>MD</i>	D3512	SHEET 3 OF 4
APPROVED	<i>MD</i>	TITLE	SCALE
DE APPR.	<i>MD</i>	WEARPLATE ASSY	NTS
DATE	13.08.28	COPYRIGHT © 2013 BY DART AEROSPACE LTD	
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D3512-3F FLAT PATTERN



**D3512-3 SPACER
MAKE FROM D3512-3F**



**DETAIL B
SCALE 2X**

RELEASED
2013-12-10
W

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240
18 GAUGE 0.050 THICK (REF DART SPEC. MS304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.19 lbs

DESIGN	DW	DART AEROSPACE LTD	
DRAWN	DW	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3512	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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